

Work Order ID 68625

Monday, April 18, 2011 4:18:58 PM



Ship 28 April

Page 1

Item ID: D350-689-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Energy Attenuating Floor Provisions

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-04-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI D9419	Rev A

100 0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-689-023 CHG001

Silvestre

JDC for CL 11-5-2

110 0.00



Packaging

Packaging

Pick Kit

Memo

0.00

R 11/5/2 U

120 0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

Silvestre

FD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68625

Monday, April 18, 2011 4:18:59 PM



Page 2

Item ID: D350-689-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Energy Attenuating Floor Provisions

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-023 Location: <u>DRAFT</u> PPP Rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Run/Stop 11/10/13 Q

11/15/13 MF

11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 4:18:53 PM

Page 1

Work Order ID: 68625

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions






Start Date: 4/19/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-23 new issue DD verified by:EC
route seq DD 10.02.12 vried byJLM IPP Rev:B revise

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10  Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	9	9			
D3025-1  Beam		Manufactured	No			110	Each	0.0000	1	1			
D3026-1  Channel		Manufactured	No			110	Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				ST177				2					
				67349				2					
D3027-1  Clip		Manufactured	No			110	Each	27.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				ST031				27					
				22566				27					
D3027-3  Clip		Manufactured	No			110	Each	19.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				ST031				19					
				22566				19					

7/1/6583

68627

67349

22566

22566

Pen/5/2 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 4:18:53 PM

Work Order ID: 68625

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions

Start Date: 4/19/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3027-5

Manufactured No

110

Each

23.0000

1

1



Clip

Location

Loc Qty

Loc Code

ST031

23

22566

23

110

Each

5.0000

4

4

D3027-7

Manufactured No



Clip

Location

Loc Qty

Loc Code

ST031

5

65828

5

110

Each

8.0000

1

1

D3234-1

Manufactured No



Doubler

Location

Loc Qty

Loc Code

ST233

8

44165

8

110

Each

9.0000

1

1

D3234-3

Manufactured No



Doubler

Location

Loc Qty

Loc Code

ST233

9

44166

9

110

Each

4.0000

1

1

D3811-041

Manufactured No



Seat Track Assembly

Location

Loc Qty

Loc Code

ST263

4

44697

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 4:18:53 PM

Work Order ID: 68625

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions

Start Date: 4/19/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

110

Each

5,895.000

14

14



Rivet

Location

Loc Qty

Loc Code

MEZZ

535

6733

535

ST317

5360

6874

5360



6874

34

MS20470AD4-5

Purchased

No

110

Each

1,898.000

34



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1898

116410

223

116893

1675



116410 1898
116893 1575

18

MS20470AD4-6

Purchased

No

110

Each

3,795.000

18



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

3795

116391

765

117395

3030



116391

18

MS20470AD5-6

Purchased

No

110

Each

1,688.000

32



Rivet

Location

Loc Qty

Loc Code

ST320

1688

105433

1688



105433

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

Monday, April 18, 2011 4:18:53 PM

Work Order ID: 68625

Parent Item: D350-689-023

Parent Item Name: Energy Attenuating Floor Provisions

Start Date: 4/19/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,525.000

9

9



Nut

Location

Loc Qty

Loc Code

ST300

2525

116391

151

116540

800

116549

774

117441

800

m116540

MS24694-S50

Purchased

No

110

Each

148.0000

9

9



Screw

Location

Loc Qty

Loc Code

ST289

48

116304

48

ST298

100

116900

100

m116304

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A
AND FLIGHT MANUAL SUPPLEMENT FMS-D350-689 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY

REFERENCE ONLY

PURPOSE

The purpose of this DSI is to add the D350-689-021 Dual High Back Seat Installation, LH, the D350-689-023 Floor Provisions Kit and the D350-689-043 Dual High Back Seat Assembly to IIN-D350-689 Rev. A. The D350-689-021/-023 Kits are compatible with the Energy Attenuating Seat rails in later AS 350/355 model aircraft.

The DSI 9419-011 Kit includes the parts that are required to convert a D350-689-011 installation into a D350-689-021 installation.

PART LIST

-011	-021	-023 /	-043	P/N	DESCRIPTION
X				DSI 9419-011	ENERGY ATTENUATING CONVERSION KIT
	X			D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
	1	X		D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
	1		X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
			2	D3016-041	SEAT FRAME ASSEMBLY
			1	D3017-041	BACK FRAME ASSEMBLY
	1			D3018-1	SEAT CUSHION
	1			D3019-1	BACK CUSHION
			1	D3021-041	TUBE ASSEMBLY
			1	D3022-1	SEAT PAN
			1	D3023-1	BACK PANEL
			3	D3024-1	SPACER
		1		D3025-1	BEAM
		1		D3026-1	CHANNEL
		1		D3027-1	CLIP
		1		D3027-3	CLIP
		1		D3027-5	CLIP
		4		D3027-7	CLIP
			2	D3031-1	LOOP
1		1		D3234-1	DOUBLER
1		1		D3234-3	DOUBLER
2			2	D3808-041	SEAT RAIL ASSEMBLY
4			4	D3809-1	SLIDING BLOCK
1		1		D3811-041	SEAT TRACK ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: Aug. 19/2008
CERT. NO.: SH02-33
ISSUE NO.: 1

A	NEW ISSUE	RF	08.08.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	ENERGY ATTENUATING PROVISION KIT	NTS
DATE	08.08.19	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

-011	-021	-023	-043	P/N	DESCRIPTION
			3	AN3-12A	BOLT
14		14		MS20426AD4-5	RIVET
34		34		MS20470AD4-5	RIVET
18		18		MS20470AD4-6	RIVET
		32		MS20470AD5-6	RIVET
			40	MS20600AD4W2	RIVET
			6	MS20600AD4W3	RIVET
9		9	23	MS21042L3	NUT (or MS21042-3)
			4	MS24693-S272	SCREW
8			8	MS24694-S3	SCREW
9		9		MS24694-S50	SCREW
4			4	MS24694-S148	SCREW
			4	MS27039-1-17	SCREW
			12	MS27039-1-19	SCREW
			23	NAS1149D0332J	WASHER (or AN960JD10L)
9		9		NAS1149D0363J	WASHER (or AN960JD10)

PROCEDURE

1. Install the under floor structure as outlined in steps 1-18 of IIN-D350-689 Rev. A and DSI 9311 Rev. A as applicable, except do not install D3032-1 Spacers. Attach D3026-1 Channel to floor using (14) MS20426AD4 rivets. Ensure D3234-1/-3 Doublers are installed per DSI 9269 Rev. A.
2. Position the D3811-041 Seat Track Assy at LBL 27.33 as shown in Figure 1 to be in-line with the existing seat rails at LBL 8.98 and LBL 19.16.
3. Transfer the attachment holes from D3811-041 Seat Track Assy to aircraft floor (9 pls) using a $\varnothing 0.201$ (#7 drill). Deburr holes. Install D3811-041 using (9) MS24694-S50 screws, (9) NAS1149D0363J washers, and (9) MS21042L3 nuts as shown in Figure 1. Torque screws to 20 to 25 in-lbs (2.3 to 2.8 Nm).
4. If converting a -041 Seat Assembly to a -043 Seat Assembly, remove D3028-1 Studs, D3029-1 Springs, and D3030-1 Locks from the D350-689-041 Seat Assembly. Install (2) D3808-041 Seat Rails Assemblies as shown in Figure 1 Detail A using (4) MS24694-S148 Screws. Torque screws to 100 to 140 in-lbs (11.3 to 15.8 Nm). Install D3809-1 Sliding Blocks using (2) MS24694-S3 screws as shown in Figure 1 Detail A. Torque screws to 12 to 15 in-lbs (1.4 to 1.7 Nm).
5. Remove screws from back end of Seat Tracks at LBL 27.33 and LBL 8.98. Slide D350-689-043 Seat Assembly into both seat tracks and lock in desired position using D3810-1 Retractable Spring Plungers. Re-install screws on back of seat tracks per the Aircraft Maintenance Manual.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: Aug. 19/2008
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9419	SHEET 2 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	ENERGY ATTENUATING PROVISION KIT	NTS
DATE 08.08.19		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

